

Work Order ID **77425*****77425***

Page 1

Item ID: **D3684-049**

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: AFT LEG ASS'Y

Stop ***NS2***

Start Date: 12/6/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 12/9/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *MF* Date: *11-12-06*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3684

Rev D

100

Pick Kit

0.00

100

Packaging

Memo

0.00

Packaging

110

Small Fab

0.00

110

Small Fab

Memo

0.00

Small Fab

1-Use anti-seize compound Tectly 502c Class 1, Mil-PRF-16173E or equivalent on thread and assemble as per dwg D3684

2-Assemble D3693-1 & D3691-1 Using Sikaflex -241/-291 between mating surfaces as per Dwg D3684

***Ensure holes for AN3C Bolts are free of sealant.

Torque Fastners as per Dwg D3684

ES 11/12/07 (1)

ES 11/12/07 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77425

77425

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Tuesday, December 06, 2011 2:19:50 PM

Item ID: D3684-049 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: AFT LEG ASS'Y
 Start Date: 12/6/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 12/9/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: GA	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

SB 11/12/07

EB 11/12/08 ①

11/12/08

MF 11-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Tuesday, December 06, 2011 2:19:50 PM

Page 1

Work Order ID: 77425

Parent Item: D3684-049

Parent Item Name: AFT LEG ASS'Y

Start Date: 12/6/2011

Required Date: 12/9/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue 08-02-12 DD verified by:JLM
 IPP Rev:B As per Rev B 09-01-07 JLM Verified By:EC
 03-16 JLM VERIFIED BY:EC
 IPP Rev:C Added sealant note as per Rev C 09-01-20 JLM Verified By:DD
 IPP REV:C AS PER REV D 10-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<u>AN3C12A</u> Bolts		Purchased	No			110	Each	90.0000	2	2		12/11/07	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				ST351		90							
				117514		4							
				118112		5							
				118422		17							
				118451		22							
				119510		42							
<u>D3688-3</u> STUD		Manufactured	No			110	Each	8.0000	1	1		12/11/07	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		8							
				69625		3							
				73459		5							
<u>D3689-1</u> SLEEVE		Manufactured	No			110	Each	11.0000	1	1		12/11/07	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		4							
				70858		4							
				ST075		7							
				72117		7							
<u>D3691-1</u> STUD		Manufactured	No			110	Each	10.0000	1	1		12/11/07	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				GA		10							
				62181		10							

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Tuesday, December 06, 2011 2:19:50 PM

Page 2

Work Order ID: 77425

Parent Item: D3684-049

Parent Item Name: AFT LEG ASS'Y

Start Date: 12/6/2011

Required Date: 12/9/2011

Start Qty: 1.00

Required Qty: 1.00

D3692-17
SPACER

Manufactured No

110 Each 141.0000

4 4

EB 11/12/07

Location

Loc Qty

Loc Code

ST075

141

51467

41

73232

100

4

D3693-11

Rod End Bearing

Manufactured No

110 Each 8.0000

1 1

EB 11/12/07

Location

Loc Qty

Loc Code

GA

8

50734

8

1

MS21043-3

Nut

Purchased No

110 Each 856.0000

2 2

EB 11/12/07

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

784

118077

1

118614

449

118686

104

119758

230

2

NAS509-12C

Nuts

Purchased No

110 Each 14.0000

1 1

EB 11/12/07

Location

Loc Qty

Loc Code

ST280

14

112453

14

1

NAS509L12C

Nuts

Purchased No

110 Each 19.0000

1 1

EB 11/12/07

Location

Loc Qty

Loc Code

ST279

19

112314

9

112828

10

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

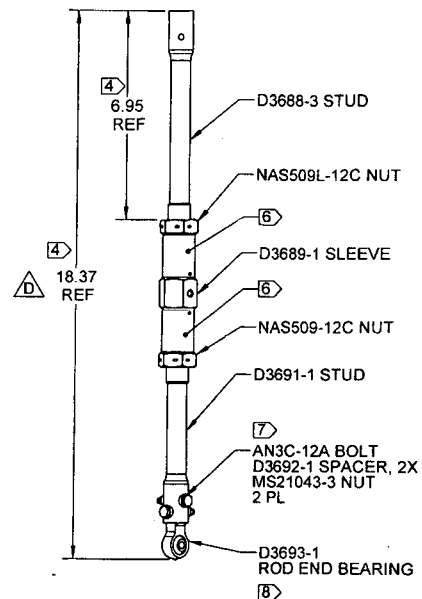
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ITEM	QTY -049	PART NUMBER	DESCRIPTION
1	X	D3684-049	AFT LEG ASSEMBLY
2	1	D3688-3	STUD
3	1	D3689-1	SLEEVE
4	1	D3691-1	STUD
5	4	D3692-1	SPACER
6	1	D3693-1	ROD END BEARING
7	2	AN3C-12A	BOLT
8	2	MS21043-3	NUT
9	1	NAS509L-12C	NUT
10	1	NAS509-12C	NUT



D3684-049 AFT LEG ASSEMBLY

NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) IDENTIFICATION: NONE
- 4) DIMENSION SHOWN IS WHEN D3688-3 & D3691-1 STUDS ARE FULLY THREADED INTO D3689-1 SLEEVE
- 5) WEIGHT: 2.86 lbs
- 6) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD
- 7) TORQUE FASTENERS TO 20-25 in-lbs
- 8) ASSEMBLE D3693-1 WITH D3691-1 USING SIKAFLEX-241-291 OR PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN MATING SURFACES. ENSURE HOLES FOR AN3C BOLTS ARE CLEAR OF SEALANT

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. D
CHECKED	RF	D3684	SHEET 5 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		TRIPOD MOUNT ASSY	NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.03.03		

RELEASED
2010-03-15

77425

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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